

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-55 Date Opened: 29 March 2017 Title: Fabrication

Aircraft OEM: Multiple Aircraft Model: Multiple Product Type: Cargo Basket Product Model: Handle Bushing Quantity: 200

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
JC
N/A
N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

222
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
KB
DB
N/A
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
36274	3	Bushing	JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Initial or N/A

Notes:

Work performed by:

Print: J. Clarke

Sign: J. Clarke

SCA: AD02

Date: 20-Jul-17

ICC / Dual Inspection performed by:

Print: N/A

Sign: J. Clarke

SCA:

Date:

Work Order closed by:

Print: J. Clarke

Sign: J. Clarke

SCA: AD02

Date: 01-Aug-17

Approved Manufacturing Facility 73-04

Form 20.003

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd, Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bushing No. of pieces: 255

Manufacturer: Aero Design Ltd

Part No.: 36274-01 Serial/Batch No.: 17024

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-55

Remaining Tasks to be Performed: Deburr, Lathe operations

Signature: [Signature]

Date: March/29th/2017 Lic. No. / SCA AD-07

In Process



Aero Design Ltd.

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AMF 73-04

In Process

Remarks

- 31 SCRAP - UNDER LENGTH 11/04/2017 JR.
- 38 completed April 12/2017 placed in stock AD-05
- 1 Scrap - under length 20 July 2017 AD-10 KH
- 1 Scrap - under length 20 July 2017 JR.

TASK TAG



Aero Design Ltd.

AMF 73-04

9888A Malaspina Road
Powell River, BC, V8A 0G3
Phone: 604-483-2376
Fax: 604-483-2372
Email: info@aerodesign.ca

Work Order: 2017-55

☐ Copy #: _____

Copies to be used for completed parts or assemblies

Nomenclature: Handle bushing, lever Total Quantity: _____

Part No.: 36274-01 Serial No.: NSN Batch/PO No.: 17024

Manufacturer: ☒ Aero Design Ltd. ☐ _____

Created by: JH CCL Date: 29 MAR 2017 SCA: _____

Closed by: JH CCL Date: 01 AUG 2017 SCA: AD02

Task Sheet: 36274-01 Rev 3 Work Order: 2017-55

Task #	SCA	SCA	SCA	SCA
1.	Qty: <u>38</u> Date: <u>April 12/2017</u> AD 73-04 05	Qty: <u>184</u> Date: <u>20 July 2017</u> AD 73-04 02	Qty: _____ Date: _____	Qty: _____ Date: _____
2.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
3.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
4.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
5.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
6.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
7.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
8.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
9.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
10.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____

Note: Qty may be left blank if all parts are covered by one stamp.

Continued on back ☐

Remarks:

Task #	SCA	SCA	SCA	SCA
11.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
12.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
13.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
14.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
15.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
16.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
17.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
18.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
19.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____
20.	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____	Qty: _____ Date: _____

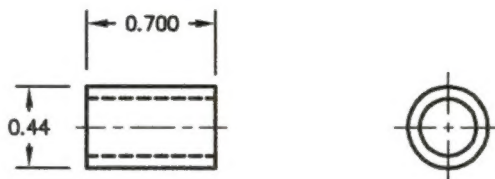
2017-55

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36210	STF	MAY 17/02
1	REMOVE ALTERNATE PART, REMOVE STEP FROM BUSHING	BJC	JAN 8/07
2	LENGTH CHANGED	BJC	NOV 03/09
3	TITLE BLOCK UPDATE, ADD ALTERNATE MATERIAL	BJC	MAR 13/14

200 x

NOTES:


1. REMOVE ALL BURRS AND SHARP EDGES.



01 BUSHING

	01	(ALTERNATE MATERIAL)	316 STAINLESS STEEL	ASTM A269	7/16" X 0.065" TUBE
36274-01	01	BUSHING	304 STAINLESS STEEL	ASTM A269	7/16" X 0.065" TUBE
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

QTY LIST OF MATERIALS

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				
	DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		ANGLES ±1/2°		
	HELICOPTER CARGO BASKET HANDLE LEVER BUSHING				
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE A4	DWG. NO. 36274	

HANDLE BUSHING FABRICATION – 36274-01

General

These instructions apply to Handle Bushing 36274-01. Refer to the following drawings, at the current revision, for dimensions and details:

36274, Revision 3 – Handle Bushing

Work Order: 2017-55

Batch Size: 200

Date Open: 21 MAR 2017

Complete
(initial or SCA #)

AG
73-04
02

1. Handle Bushing Fabrication

- a. Cut 7/16" x 0.065" round Stainless Steel material to 0.75 long.
- b. Record material PO: 17024
- c. De-burr one cut end using buffing wheel.
- d. On lathe, install 7/16 collet chuck. Set stop inside collet so stock protrudes from collet.
- e. Insert stock in collet, buffed end in, against stop.
- f. The following operations may be performed all during one setup or individually for each part.
For large batches it is quicker to do each step individually.
 - i. Face end at 1380 RPM, feed at 0.01"/rev.
 - ii. Deburr OD and ID at 425 RPM.
- g. Insert part in collet, faced end in, against stop.
- h. The following operations may be performed all during one setup or individually for each part.
For large batches it is quicker to do each step individually.
 - i. Face end at 1380 RPM, feed at 0.01"/rev.
 - ii. Deburr OD and ID at 425 RPM.
- i. Inspect Bushings for conformity to drawing.
- j. Green tag complete and inspected Bushings and place into stock.